

Date: Monday, 6/19/2006 11:30:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 27645		
Estimate Number	: 10089		
P.O. Number	: N/A	Part Number	: D312123
This Issue	: 6/19/2006 S.O. No. : N/A	Drawing Number	: D3121 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 26936	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/26/2006 Qty: 100 Um: Each
Checked & Approved By	: <u>06.06.19 W</u>		
Comment	: Est. A: 04.02.19 New Issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 151106.06.19/06100

Bearing as per Dwg D3121

Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-2Z

Material release note is required

2.0

6900ZZ

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Bearing

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

06/06/20100

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect diimensions as per Dwg D3121 and attached certification Dwg Rev D06.06.21 100
QSP 019

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SI06.06.21 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: P Date: 06/06/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:30:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 27645

Part Number: D312123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 100
100/06/21

Job Completion



Handwritten: 4/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

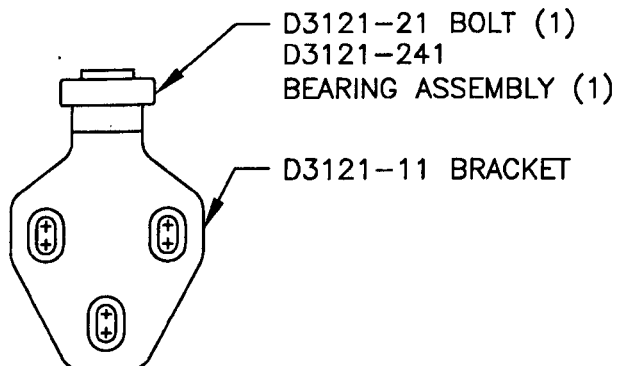
QA: N/C Closed: _____ Date: _____



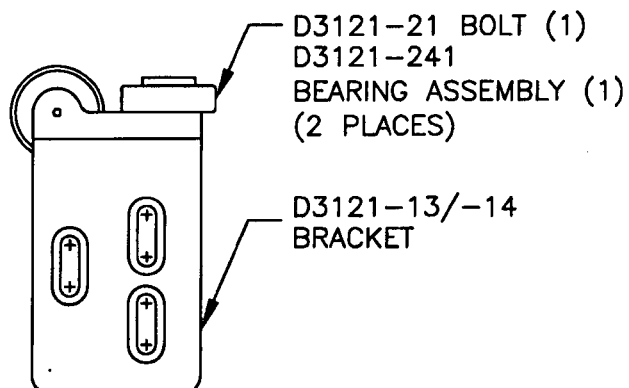
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J.H.	A	D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

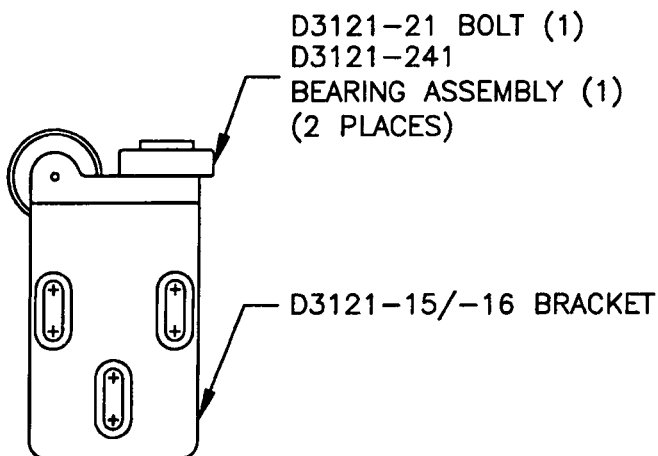
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

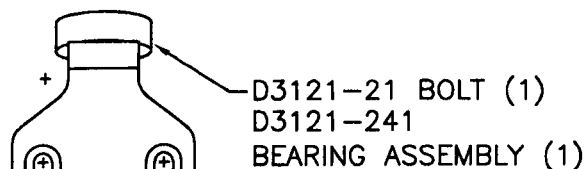
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		D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2



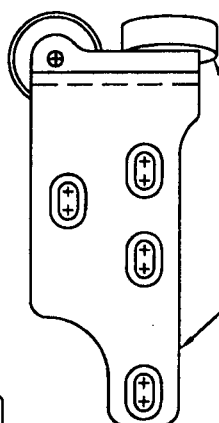
D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED

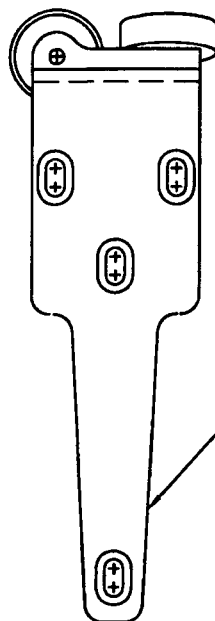
06.06.02



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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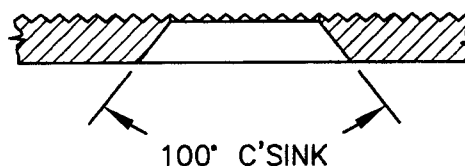
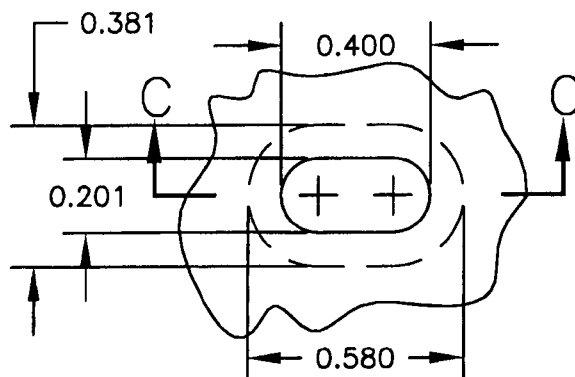
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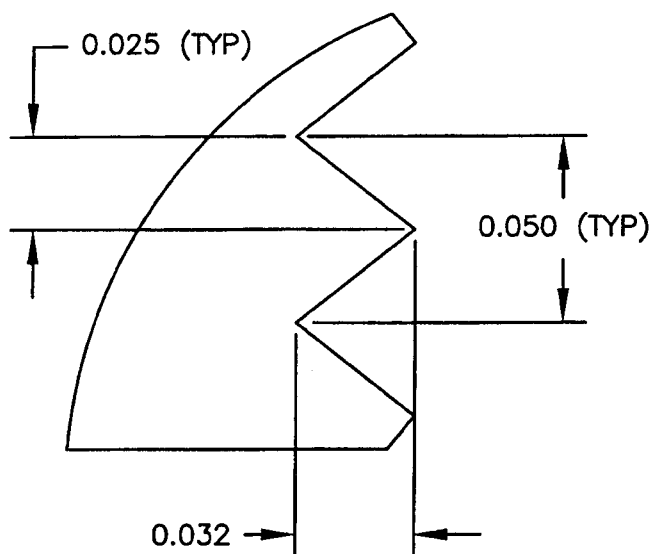
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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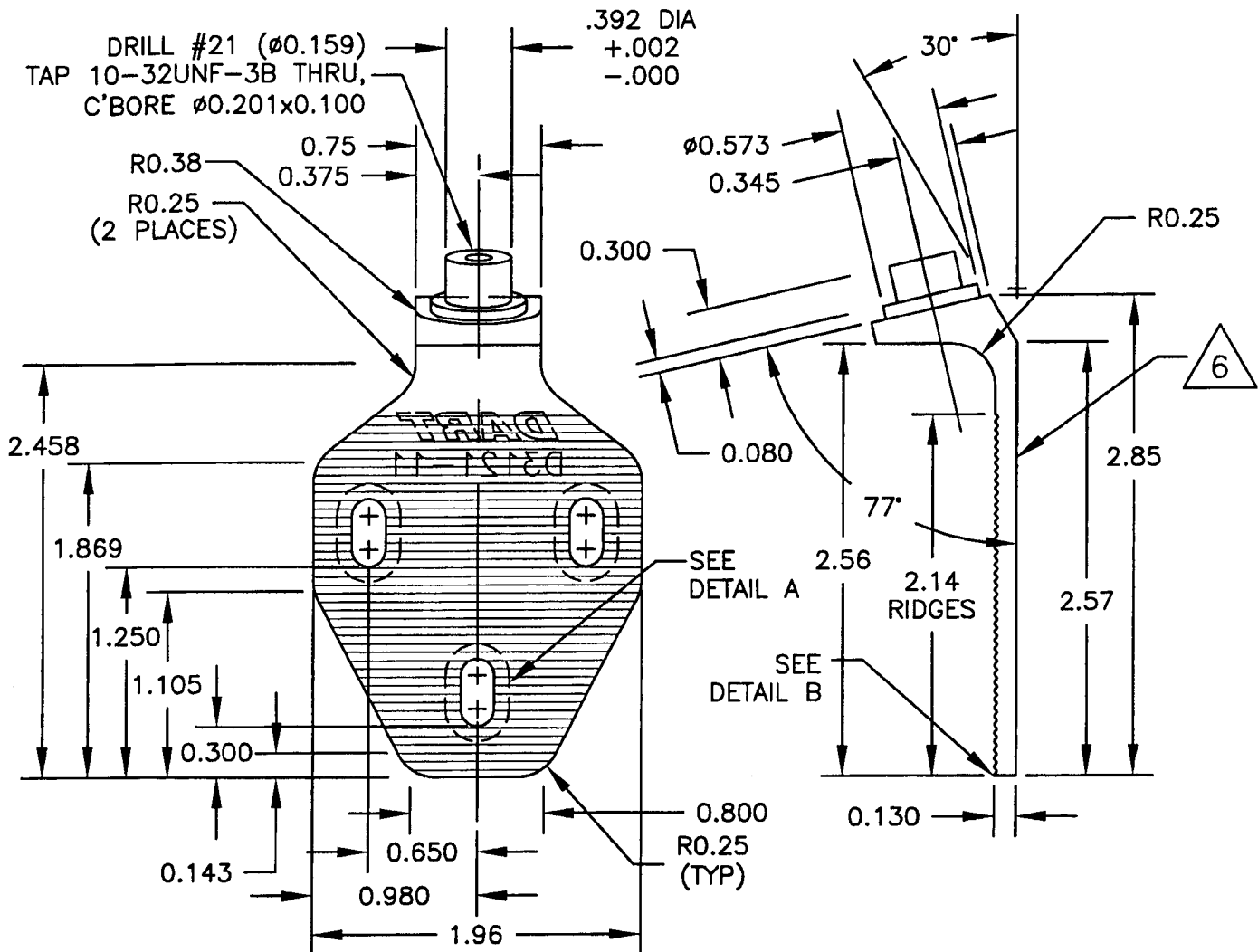
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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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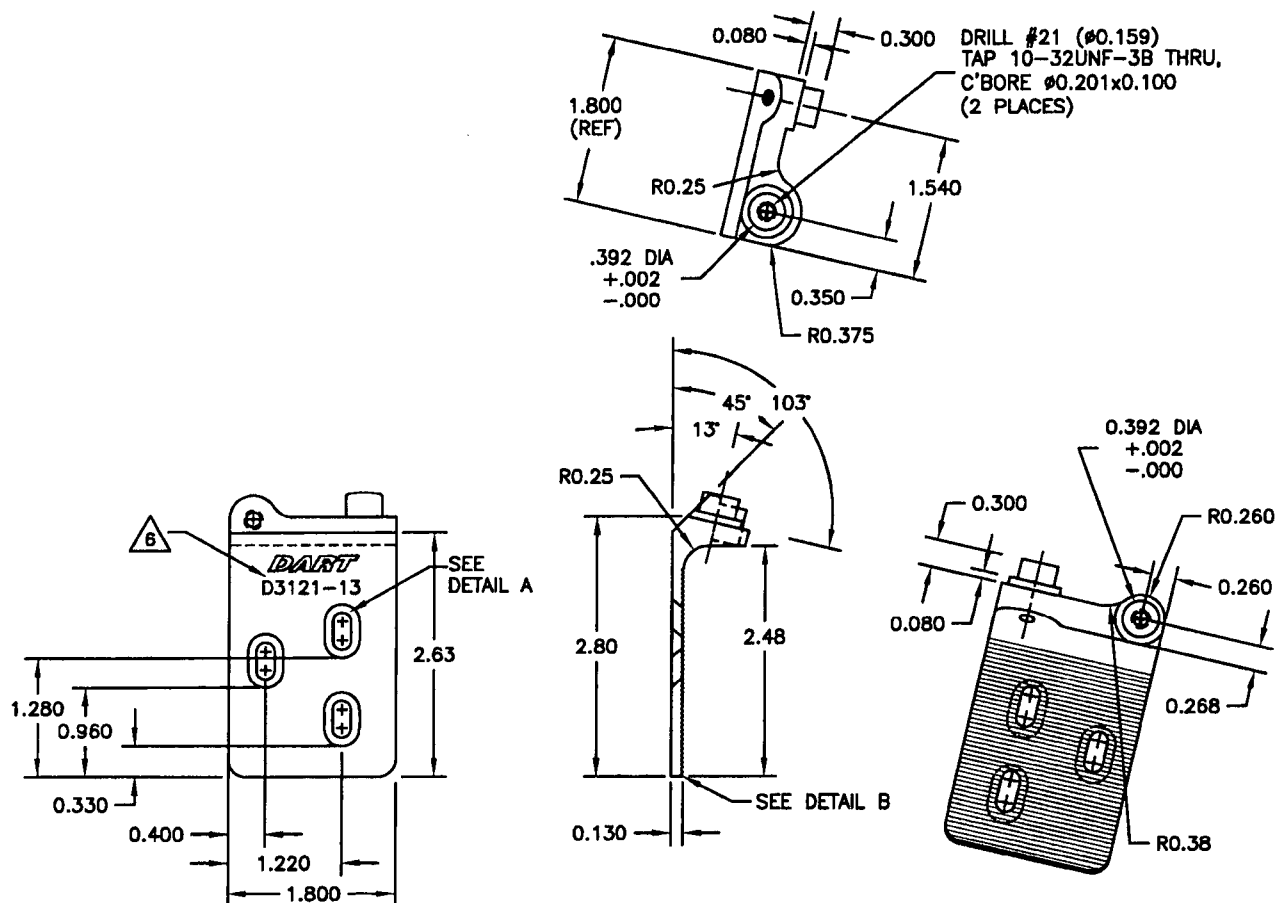
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		D3121	SHEET 5 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2

**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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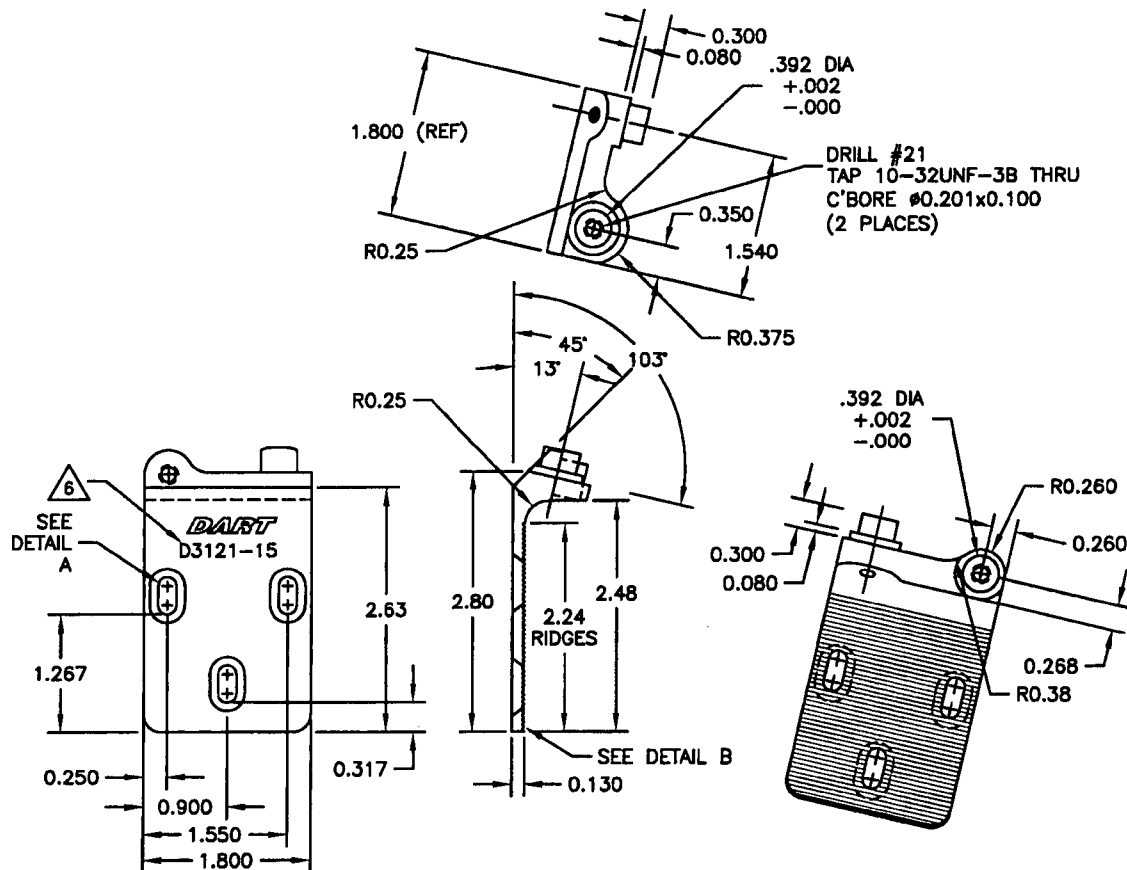
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N AND LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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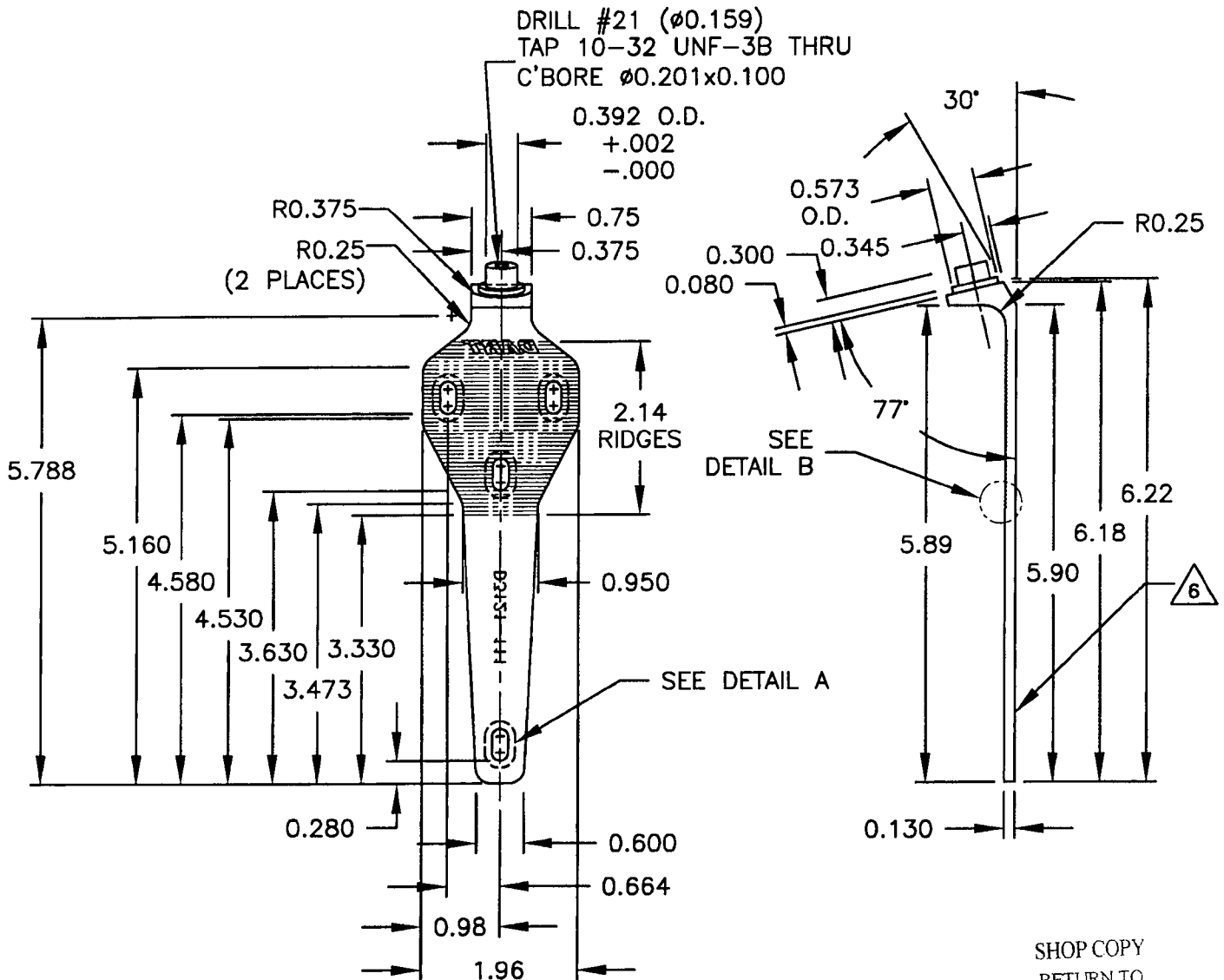
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2

**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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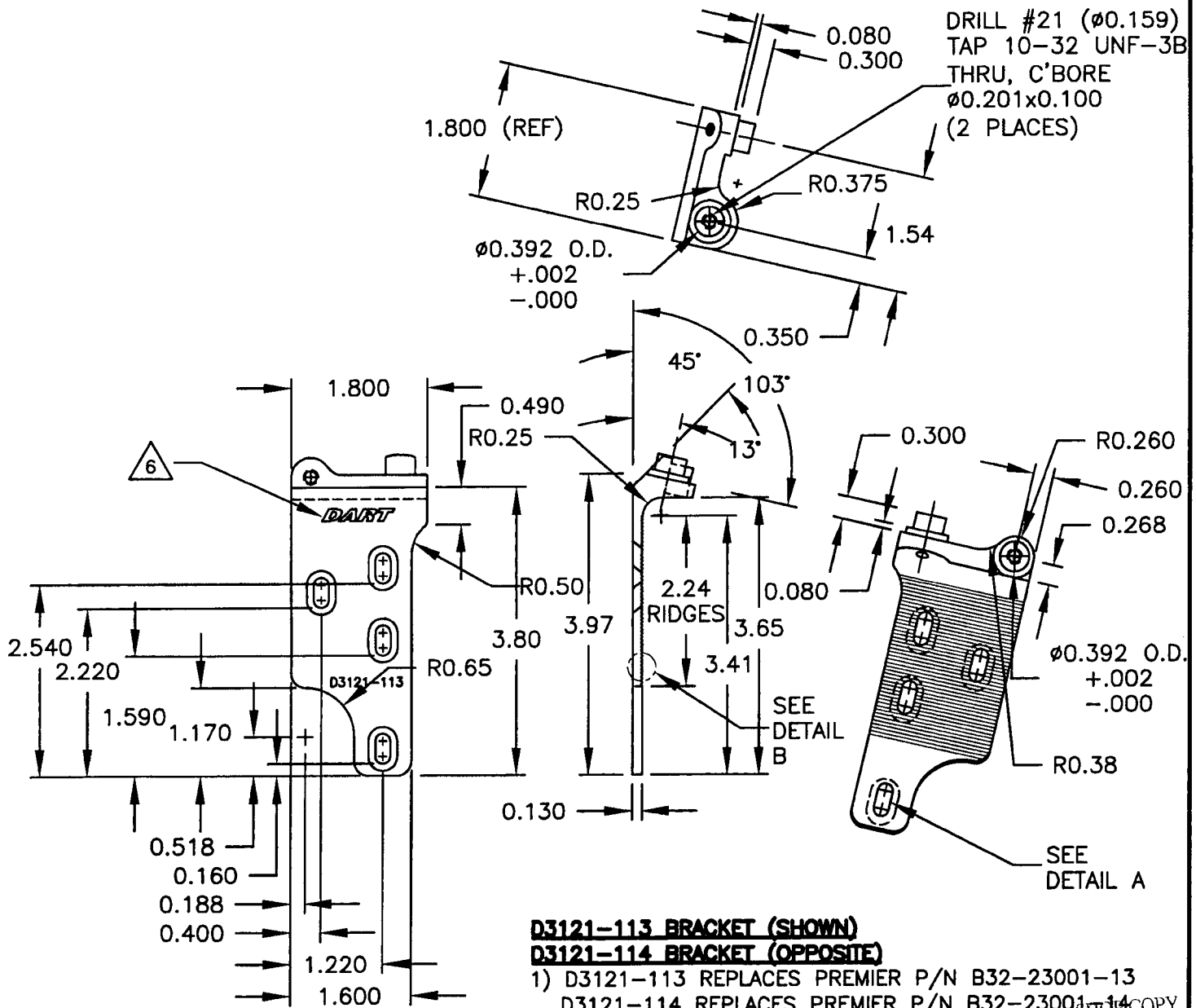
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		D3121	SHEET 8 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2



D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASE

06.06.02

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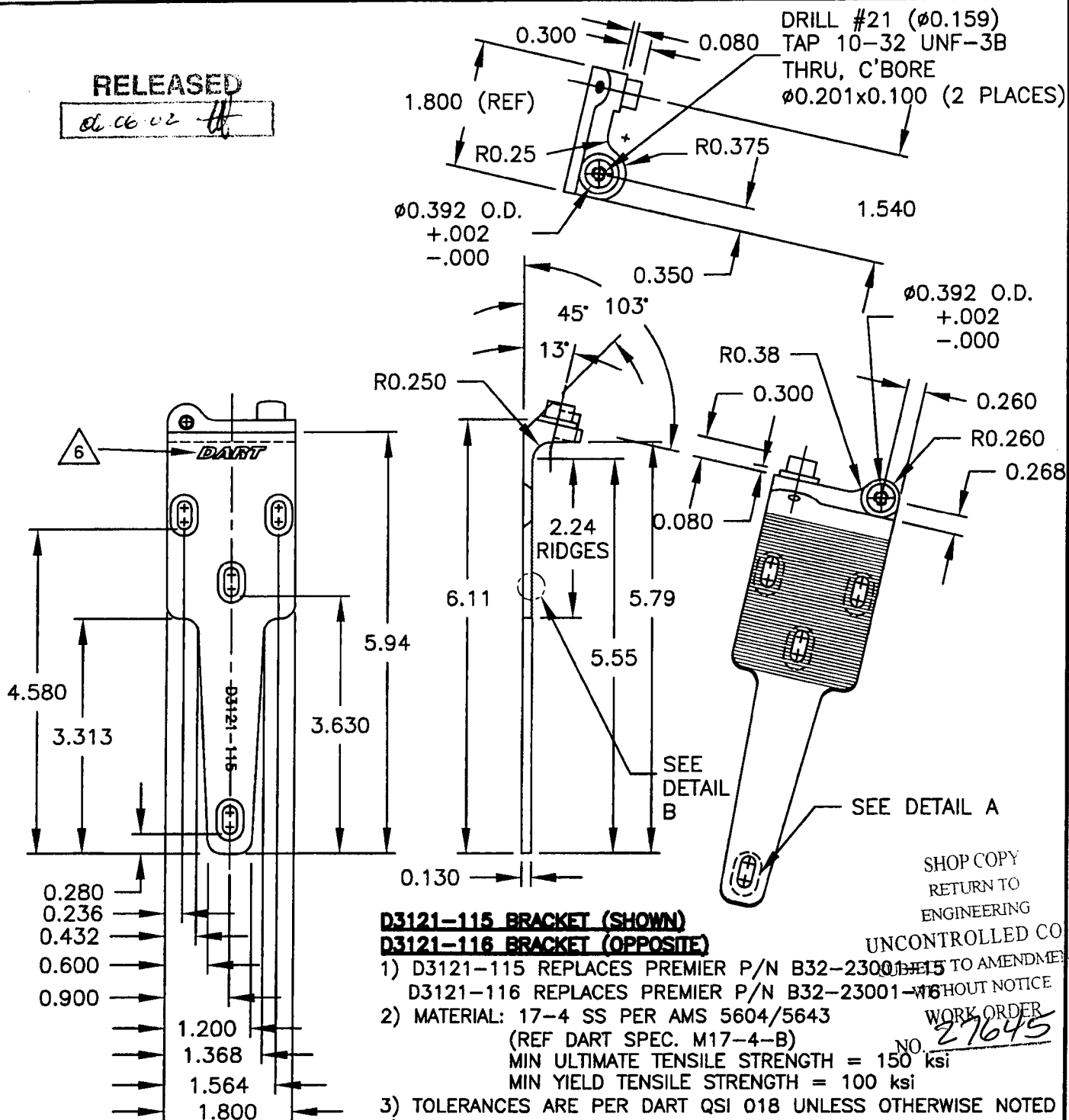
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED

06.06.02

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-115
D3121-116 REPLACES PREMIER P/N B32-23001-116
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK ORDER

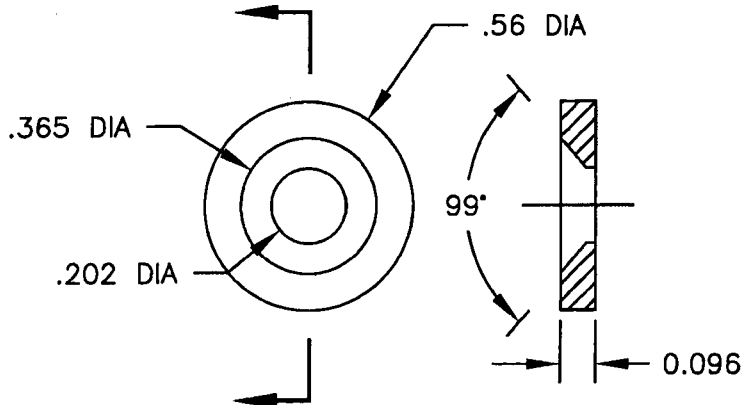
NO. 27645

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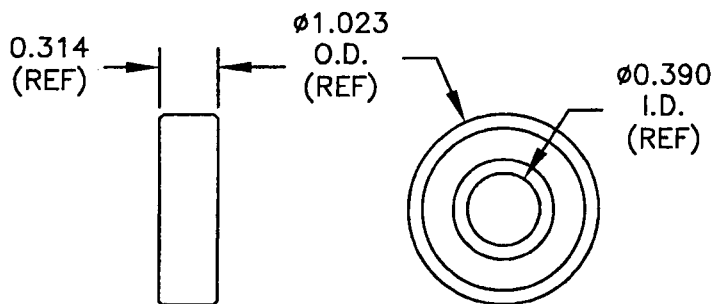
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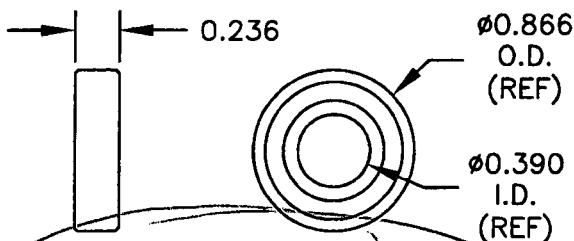
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CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:1

**D3121-17 WASHER (SCALE 2:1)**

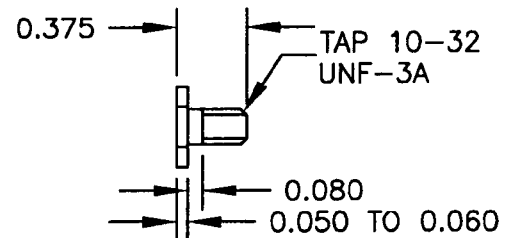
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

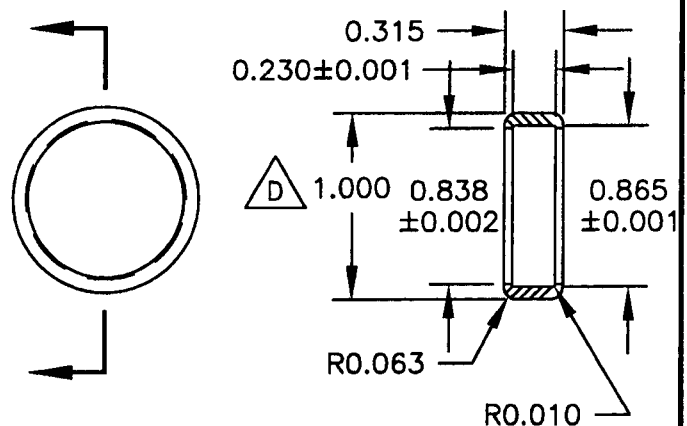
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

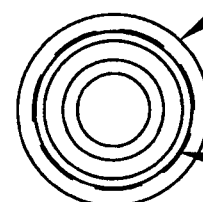
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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06.06.02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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WORK ORDER
NO. 27645
D3121-23
BEARING

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GENERAL BEARING SERVICE INC.

WWW.GBS.CO

GENERAL BEARING SERVICE

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979004

ORDER DATE: JUN 20, 2006

SOLD TO: DART AEROSPACE LTD.
1270, HERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: DR
SHIP VIA:

CUSTOMER ORDER #: 000081511

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6900-7Z	BALL BEARING	100	100	4.97	497.00

6900-7Z

BALL BEARING

100

100

4.97

497.00

34.79

G.S.T.

604/42

PACKING SLIP NO: 194863-0

RECEIVED BY:

Wally Kiser

0001400